

29

DART AEROSPACE LTD	Work Order:	19349
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	15 Kits
Ref: K10008 Rev. E		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	JA	03.06.17	15																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	For K5 WK 27 JA	03-06-26	15																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: M13307	SP	03-06-18	15																																																
4	MV	Inspect material for defects or damage prior to machining	SP	03/06/18																																																	
5	MV	Machine as per Folio D2432 and Dwg D2432	SP	03/06/18																																																	
6	QC2	Inspect parts as they come off the CNC machine	SP	03/06/18																																																	
7	MV	Deburr	SP	03/06/18																																																	
8	QC8 & 5	Second inspection	E	03/06/18																																																	
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B18914</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B18971</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B19349</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B18965</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B18529</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B18966</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M12092</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M12749</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M12020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B18914	12	D2274	Radius Block	B18971	2	D2432F	24" Bearpaw	B19349	6	D2438	Clamp	B18965	12	D2529	Washer	B18529	6	D2732-050	Rubber Cushion	B18966	12	AN4-15A	Bolt	M13437	12	AN4-17A	Bolt	M12092	24	AN960JD416	Washer	M12749	12	MS21042L4	Nut (or -4)	M12020	1	Paperwork package from Step 2			①	03-06-26	15
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SB	03-06-26	15																																																
11	PK	Identify and pack for shipping as per PPP K10008 REV. E	① SB	03-06-26	15																																																
12	AC	Cost / part 22258	SP	03-06-27	15																																																
13	DC	Close W/O 227.62 Inspect Level 21	SP	03.06.27																																																	

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	

RELEASED
03.06.17 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 16, 2003
02:42 pm

Work Order No : 0019349
Project Name : *K10008
Project For : WK329
Work Order Type : Main
Main WO Number :
House Part Number : *K10008
Description : Bearpaw kit 19" x 24"
Manufactured : Yes
Amount Req'd : 15
Amount Done : 0
Start Date : 06-16-03
Est Finish Date : 07-15-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Dart Aerospace, Ltd

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet ____ of ____

INSPECTION CHECKLIST

PART NO.: 12432

PHY. CHANGE: _____

DESCRIPTION: Beam

DRAWING CHANGE: REV. F

MANUFACTURING DATE: 03/06/18

UNICORP E.O.'S: _____

BATCH NO.: _____

SERIAL NO.: _____

PURCHASE ORDER NO.: _____

QUANTITY ACPT. _____ REJ. _____

DATA SHEET NO.: _____

☒ FIRST ARTICLE

☐ PERIODIC CONFORMITY

☐ FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	19.000	±.010	19.000	✓		100%	H-G	
1	1	0.260	±.005	0.260	✓			Vern	
1	1	0.30	±.005	0.300	✓			D-Mic	
1	1	0.43	±.005	0.430	✓			Vern	
1	1	2.3750	±.010	2.3750	✓			H-G	
1	1	3.375	"	3.375	✓			Vern	
1	1	7.375	"	7.375	✓			"	
1	1	11.625	"	11.625	✓			"	
1	1	2.000	"	2.000	✓			"	
1	1	2.375	"	2.375	✓			R-G	
1	1	2.500	"	2.500	✓			"	
1	1	11.000	"	11.000	✓			Vern	
1	1	20.000	"	20.000	✓			H-G	
1	1	0.063	±.010	0.063	✓			Vern	
1	1	5.500	"	5.500	✓			"	
1	1	0.200	"	0.195	✓			D-Mic	
1	1	0.20	±.005	0.200	✓			Vern	
1	1	0.375	±.010	0.375	✓			Mic	
1	1	0.500	"	0.500	✓			"	
1	1	0.530	"	0.549	✓			"	

H:\admin-qaliso\forms\first article inspectionA

Rev. B

Measured by: [Signature]

Audited by: [Signature]

Approved by: N/A